

5/43

DART AEROSPACE LTD	Work Order:	24573
Description: Wearpad	Part Number:	D3429-1
Drawing: D3429 Rev. A	Qty:	10
Page 1 of 1		

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler Dwg not required	HA	05.10.17	10
2	PG	Issue P/O: <u>700832</u> Email or ship DXF file to vendor Laser Cut D3429-1 Flat pattern as per Dwg D3429 Material release note required	U	05.10.17	10
3	RG	Receive and Inspect for transit damage Ensure the material release note is attached	CL	05/10/17	10
4	QC6	Inspect dimensions as per template D3429-1T1	J	05.10.17	10
5	GB	Deburr if necessary		N/A	
6	GB	Form on Brake as per Dwg D3429 using Jigs DT8261 and DT8326. Identify as D3429-1	SB	05/10/18	10
7	GB	Form Joggle as per Dwg D3429 on brake using Jig DT8158	SB	05/10/19	10
8	WS	Weld hardcoat as per Dwg D3429 <u>Qty</u> <u>Description</u> <u>Batch</u> A/R 7560Hardcoat <u>M18838</u>	CP	05/10/21	9
9	QC9	Inspect weld	HA	05/10/31	9
10	QC5	Inspect work to Step 9	HA	05/10/31	9
11	FP	Powder Coat Grey Sandtex (Ref. 4.3.5.6) as per QSI 005 4.3	HA	05/11/01	9
12	QC3	Inspect Powder Coat	HA	05/11/01	9
13	FP	Identify and Stock	HA	05/11/01	9
14	AC	Cost / part: <u>16.35</u>	Sur	05-11-03	9
15	DC	Close W/O <u>16.35</u> Inspect Level 21	G	05/11/03	9



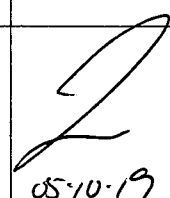
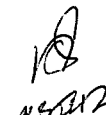
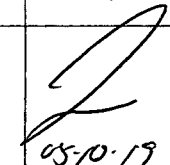
PTO

Rev	Date	Change	Revised By	Approved
A	05.10.04	New Issue	KJ/EC	EC

RELEASED
05.10.05

Q

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC-Inspector

NCR: 24573		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-10-19	7	Joggle formed opposite to Dwg on 1 part		Scrap: destroy	 05-10-19	 05-10-19	 05-10-19	 05-10-19

Part No: D3429-1 PAR #: N/A Fault Category: Prod / FAB. ISS ^{med-small} NCR: Yes No DQA: DP Date: 05/11/02

NOTE: Date & initial all entries

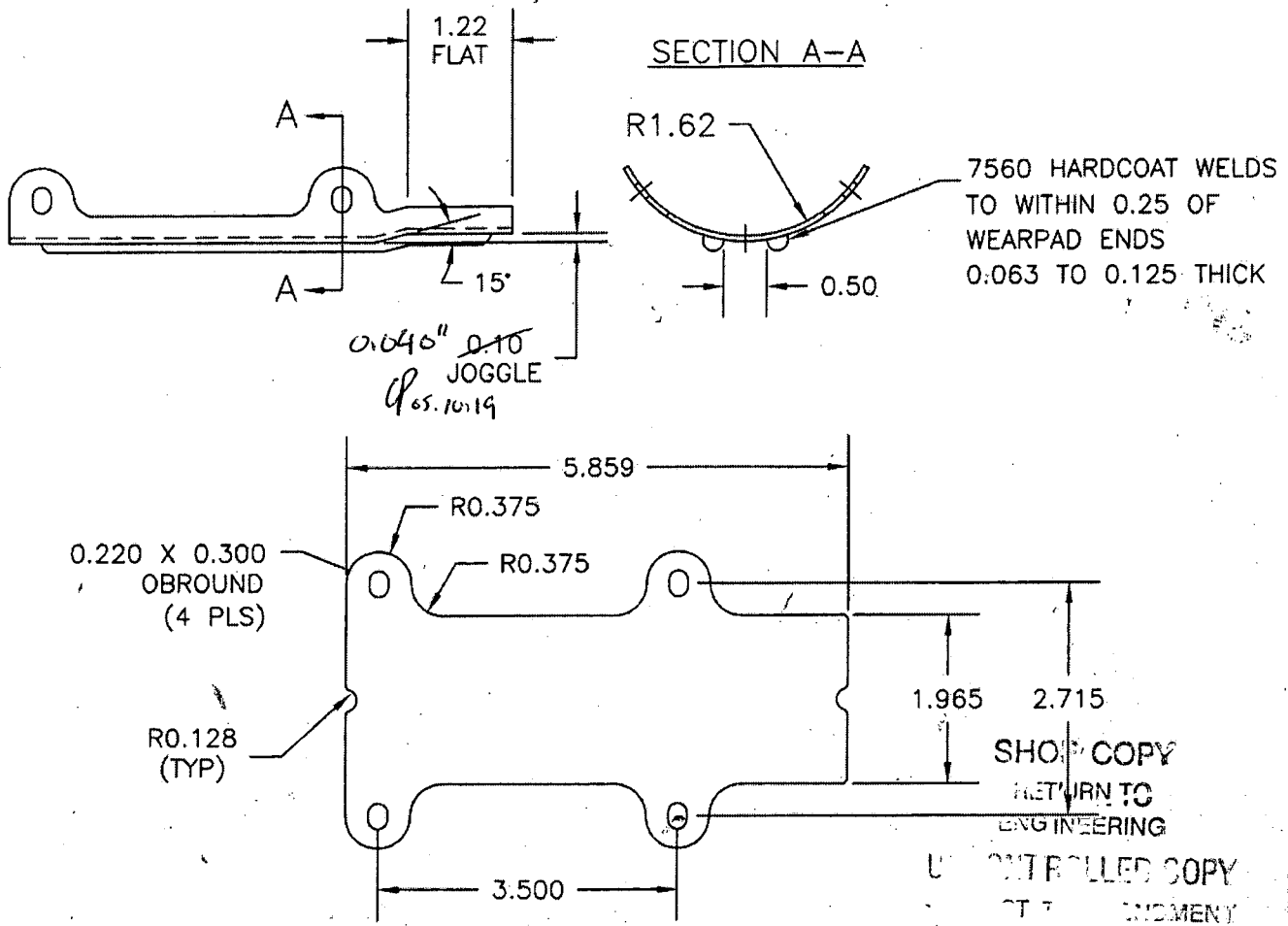
QA: N/C Closed: 10

Date: 05.11.02



DESIGN CP	DRAWN BY CP	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3429	REV. A SHEET 1 OF 1
DATE 05.04.18	TITLE WEARPAD		SCALE 1:2
A	05.04.18	NEW ISSUE	

RELEASED
05.09.06



D3429-1 WEARPAD

- 1) BREAK ALL SHARP CORNERS 0.063 MAX
- 2) MATERIAL: 16 GAUGE AISI 1010-1025 OR ASTM A36/A366 STEEL (0.063 THICK)
- 3) FINISH: POWDER COAT GREY (REF. 4.3.5.5) PER DART QSI 005
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) WELD PER DART QSI 004

WORK ORDER
NO. 24573

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Oct 17, 2005
02:00 pm

Work Order No : 0024573
Project Name : D3429-1
Project For : WK543
Work Order Type : Main
Main WO Number :
House Part Number : D3429-1
Description : Wearpad
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 10-17-05
Est Finish Date : 10-17-05
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00
Order Entry No :
OE Value : 0.00
Est Mark Up : 0.000%
Actual Mark Up : 0.000%
\$0 Posted to Finished Goods

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

Purchase Order

PO Number 2008136
Date 05-30-05
Account # QSI012-6100

Vendor
Industrial Laser Cutting
#7-7504 Vantage Place
Delta BC
Canada V4G 1A5

Sold To
Dart Aerospace Ltd.
1270 Aberdeen St.
Hawkesbury ON
Canada K6A 1K7

Ship To
S A M E

Attn Jeff/Fenella
Vendor Tel (604) 946-4152
Vendor Fax (604) 946-4153

Purchaser
Telephone (613) 632-3336
Fax (613) 632-4443

Ship Via PUROLATOR GST # RT101272607 PST # 61225207 OE # 0080304
FOB Point ORIGIN Comments: MATERIAL CERTIFICATION REQUIRED UPON DELIVERY
Freight Chgs Collect

Amt	Manuf	Mfg Part No	Our Part Number	Part Description	Delivery	Unit Price	Extended
10.00			.D3413-1	RING	06-10-05	17.7700 /U	177.70
		PER DRWG D3413 REV.A					
20.00			.D3414-1	LUG BRACKET	06-10-05	5.8100 /U	116.20
		PER DRWG D3414 REV.A					
12.00			.D3415-1	NUT PLATE	06-10-05	2.3250 /U	27.90
		PER DRWG D3415 REV.A					
10.00			.D3429-1	WEARPAD	06-10-05	4.1800 /U	41.80
		PER DRWG D3429 REV.A					

24417 100
P 601-534

Total Value of Purchase Order

\$363.60

Товаросопроводительный документ №
Shipping document No

0080312775



CERTIFICATE OF QUALITY

ISPAT KARMET

Продавец (экспортер)
Seller (exporter)

Контракт №
Contract No

KX0939

Ссылка
Ref. No

CA012

4379

ISPAT-KARMET
Karaganda obl, g. Temirtau
Republic of Kazakhstan

Приложение
Annexure N

012

Варов. №
Wagon No

67501734

Грузополучатель, страна
Consignee, country

124
Canada

There is no radiation contamination of metal,
natural background up to 0.2 mR/hour.
Control is done with DPR-1074. V. 00930 dominates
Certificate about governmental verification RA.17. exp.
dated 04.07.2003

P30X1801001

ASTM A1008M-02

ASTM A1008M-02

ASTM A 568M-95

НТД
Standard

.059 x 48

Показатели качества товара

Quality characteristics of goods

Комара плавки Heat No	Номера партии Batch No	Химический состав (%) Chemical composition (%)											Количес- тво Quantity	Группа поверх- ности Surface group	Сорт Grade
		C x 100	Si x 100	Mn x 100	S x 1000	P x 1000	Cr x 100	Ni x 100	Cu x 100	As x 100	N x 1000	Al x 100			
333005	9204	7.0	1.0	36.0	22.0	22.0	1.0	3.0	4.0		4.0		8		1

Номера партии Batch No	Механические свойства Mechanical characteristic							Харак- тер свойств Edge classi- fica- tion	Лист конт- ности Flat ness	Класс качества category	Ка- тего- рия category	Вид марки- ровки Marking
	Предел прочности UTS N/mm2	Предел текучести Yield Strength	Удли- нение Percent Elonga- tion	Твер- дость Hard- ness (HRB)	Холод. сгиб Cold bend test	Экстен- зиометр Erichsen	Степень Бриза Braz					
9204	365.0 365.0	240.0 230.0	37.0 38.0		UD			CUT Ra=1,0;0,9				

Указанный в настоящем документе товар соответствует по составу и свойствам в Казахстане стандарту и может быть отгружен на экспорт. При перепродаже считается, что покупатель несет ответственность за качество товара, указанного в этом документе, и за соответствие стандартам. The goods may be exported. Responsibility for the quality of the goods is transferred to the buyer upon export.

Маркировка
Marking

SPC Kazakhstan Ltd. Temirtau Operations
Minerals
PRODUCT DATA Summary to the 21st edition

Signature
Date

FUSHKINA

2003-12-03

Wilkinson Steel

Feb. 4. 2004 12:43M

No. 8193 P. 2/2

1694 m3

Chris Provencal

From: David Shepherd [davids@dartaero.com]
Sent: October 18, 2005 5:37 PM
To: Chris Provencal
Subject: Re: D3429-1

Just say no to drugs!

If I understand you correctly, you just have to update your drawing to correct the joggle from 0.1" to 0.030"/0.040". Update the drawing by hand or by electronic, whatever is easiest and we will eventually submit with the next batch of changes. This is a very minor change and shouldn't hold up production. Go ahead and approve it for this batch.

David

----- Original Message -----

From: "Chris Provencal" <cprovencal@dartaero.com>
To: <davids@dartaero.com>
Sent: Tuesday, October 18, 2005 2:57 PM
Subject: D3429-1

>
> Dave,
>
> The D3429-1 wearpad again: the dwg gives the joggle as 0.10", on the
> produced piece it is about 0.03". This is expected as they used the
> existing tool which makes a 0.040" joggle. A picture is attached.
>
> I think this should be OK. The wearplate underneath is 0.040" thick, so I
> don't know why I made it a 0.10" joggle. I think I added the two
thickness
> then dimensions the wrong surfaces, from the surfaces shown in the dwg it
> should be 0.040" joggle.
>
> The previous issue with the flat only being 1.00" long instead of 1.22"
has
> been resolved. At first they thought the joggle was going the other way,
> but the way it is actually going they can make it to the length to the
dwg.
>
>
> Sincerely,
> Chris Provencal
> DART Aerospace Ltd.
> Email...cprovencal@dartaero.com
> Phone...613-632-3336
> Fax.....613-632-4443
>
>